

Work Order ID 128261

Tuesday, January 13, 2015 12:39:11 PM

128261

Page 1

Item ID: 647.7714 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Strut Tube
 Start Date: 1/13/2015 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 1/13/2015 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: MLS Date: 1501-13 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
647.7700	A								
110		0.00							
110									
Mill Conv	Memo	0.00				20	0		J.C.L. 15/01/14
Conventional Milling Machine	1- CUT AS PER DWG 2- Mill end of tube as per dwg 3- DEBURR AS PER DWG								
120	QC6- Inspect dimensions to drawing	0.00							
120									
QC	Memo	0.00				20			DAS 38 9-88 JAN 20 2015
Quality Control									
130	Identify as per dwg & Stock Location: <u>W/A007</u>	0.00							
130									
Packaging	Memo	0.00				20			EL 15-1-21
Packaging	***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***								

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Item ID: 647.7714

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Strut Tube

Start Date: 1/13/2015

Start Qty: 20.00

20

Cust Item ID:

Required Date: 1/13/2015

Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

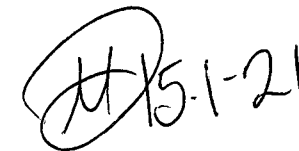
Memo

0.00

Quality Control

MCS

1501-21



Picklist Print

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Work Order ID: 128261

128261

Parent Item: 647.7714

647 7714

Parent Item Name: Strut Tube

Start Date: 1/13/2015

Required Date: 1/13/2015

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP REV:A 15.01.07 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M4130NT0.500W.083

Purchased

No

f

26.9160

13

M4130NT0 500W 083

J.C. - L1

4130 RD tube .500 x .083W

Location

Loc Qty

Loc Code

MAT032

26.916

123724

5.833

124293

21.083

5.833

5.573

13/01/19

APICAL

INDUSTRIES, INC.

ENGINEERING CHANGE NOTICE NO.

04741

SHEET 1 OF 1

DWG NO. 647.7700

REV: NC

PREPARED BY J. SOTO

DATE: 11/13/2014

EFFECT ON DWG
☒ INC. ☐ UNINC.

DWG TITLE: STRUT ASSY

APPROVED BY:

ENGR

[Signature]

MFG

[Signature]

QC

[Signature]

EFF.

NEXT ORDER

TRANSACTION CODES (TC):
A-ADD C-CREATE
R-REVISE D-DELETE

REASON: CREATED NEW CONFIGURATION. ADDED F/N 5.

SHIP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 128261.415
1501-13

5	A	647.7714	1	STRUT TUBE	△	
4	R	647.7713	1	STRUT THREAD	△	△
3	R	647.7712	1	STRUT TUBE	△	
	C	647.7703	X	STRUT ASSY		
F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL	SPECIFICATION
		7703				

DOCUMENTS EFFECTED:

☐ MDL ☐ INSTALL INSTRUCTIONS ☐ ICA ☐ FMS ☒ BOM

CHANGE CATEGORY

☐ MAJOR ☒ MINOR

DER REVIEW REQUIRED

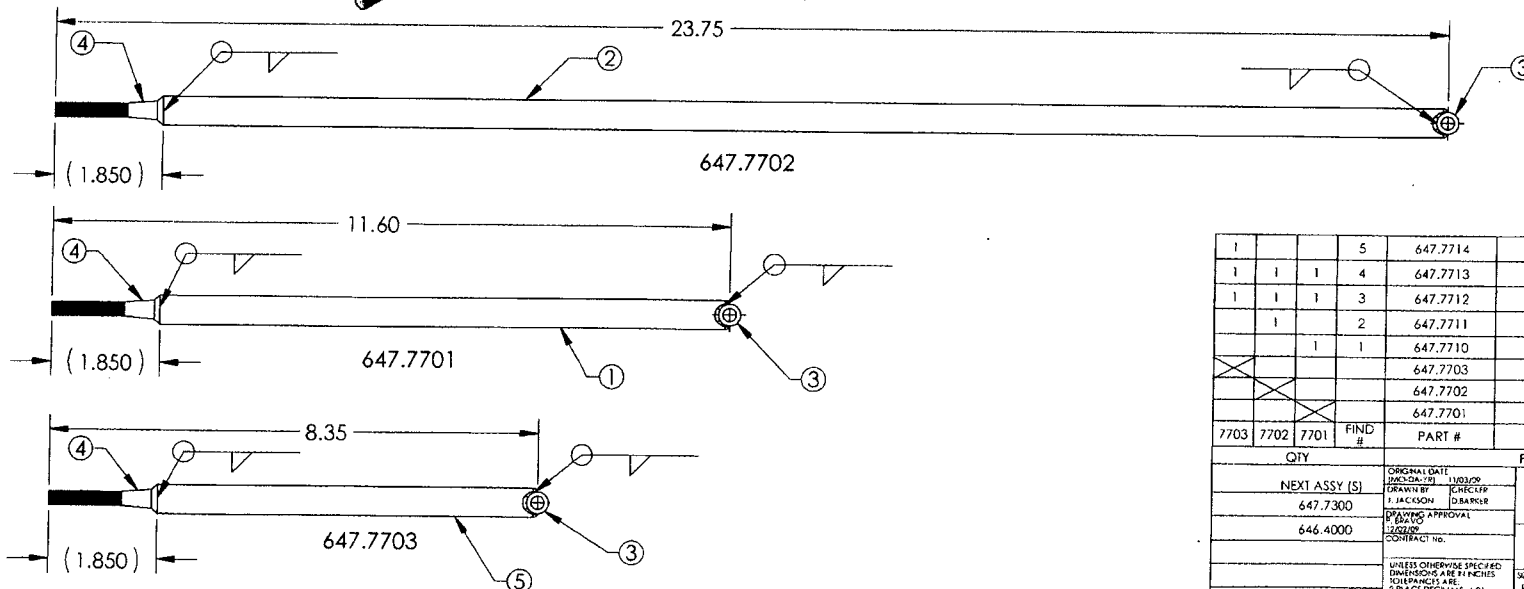
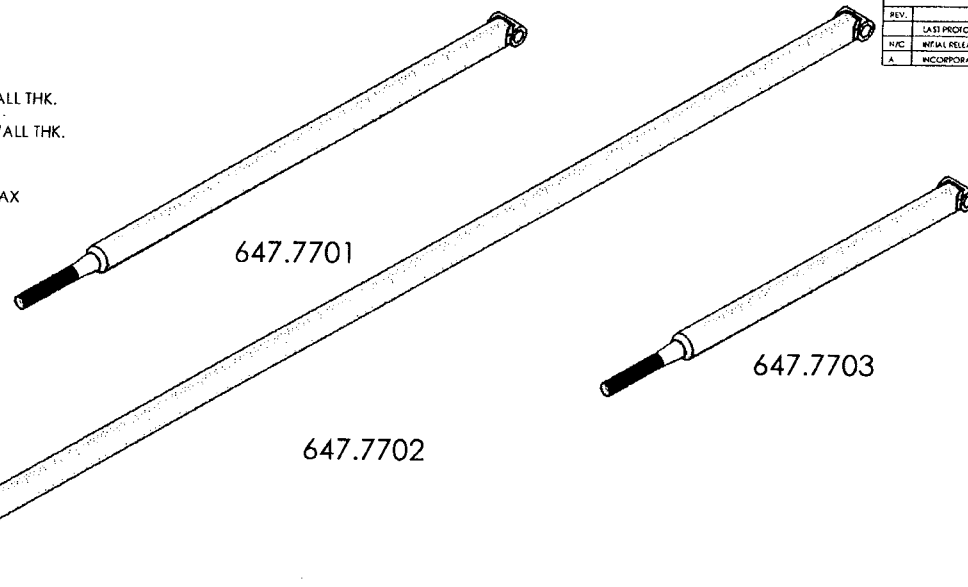
☐ YES ☒ NO

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NOTES:

- △ MATERIAL: 4130 STEEL PER AMS-T-6736, .50" OD, .083" WALL THK.
- △ MATERIAL: 4130 STEEL PER AMS-T-6736, .375" OD, .075" WALL THK.
- △ MATERIAL: 4130 STEEL PER AMS-T-6736, .324" OD.
- △ FINISH: PRIME IAW MIL-P-2337J TYPE I CLASS N; 1-2 MIL MAX
- 5. DEBURR AND BREAK ALL SHARP EDGES
- 6. IDENTIFY IAW MPP-120.
- △ WELD IAW MIL-STD-2219, TIG WELD WITH FILLER ROD
- △ FINISH: CAD PLATE IAW MIL-C-5541 CLASS 1A
- △ MASK THREAD PRIOR TO FINISH

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
1	LAST PROTOTYPE REVISION: P2		NIC
2	INITIAL RELEASE	12/05/09	P. BRAVO
3	INCORPORATED ICH DATA	11/13/11	P. BRAVO



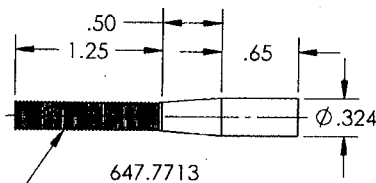
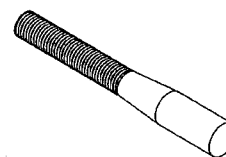
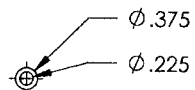
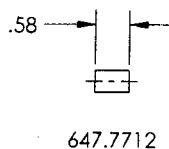
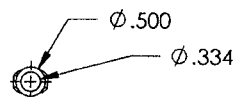
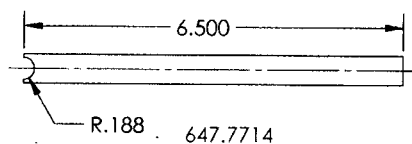
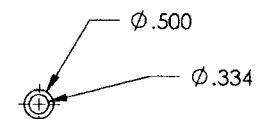
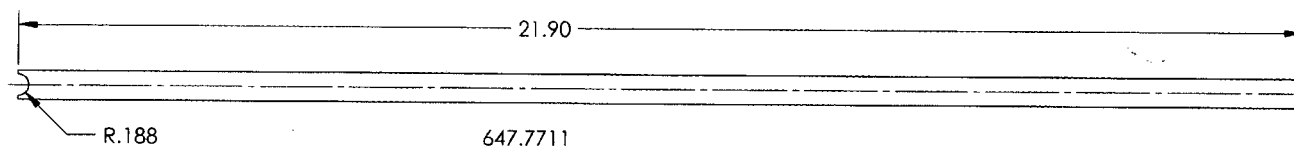
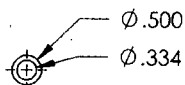
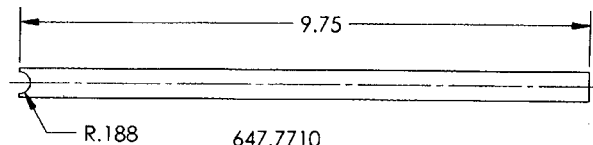
1			5	647.7714	STRUT TUBE	△	
1	1	1	4	647.7713	STRUT THREAD	△	△
1	1	1	3	647.7712	STRUT TUBE	△	
	1		2	647.7711	STRUT TUBE	△	
		1	1	647.7710	STRUT TUBE	△	
				647.7703	STRUT ASSY		△△
				647.7702	STRUT ASSY		△△
				647.7701	STRUT ASSY		△△
7703	7702	7701	FIND #	PART #	DESCRIPTION	MAT'L	SPEC.
QTY				PARTS LIST			
NEXT ASSY (S)				ORIGINAL DATE			
647.7300				2/03/00			
646.4000				DRAWN BY			
				1. JACKSON			
				DRAWING APPROVAL			
				P. BRAVO			
				CONTRACT NO.			
				UNLESS OTHERWISE SPECIFIED:			
				DIMENSIONS ARE IN INCHES			
				TOLERANCES ARE:			
				3 PLACE DECIMALS ±.01			
				ANGLES 2.5°			
				SCALE NONE			
				SHEET 1 OF 2			

APICAL INDUSTRIES
 2609 TEMPLE HEIGHTS DR.
 OCEANSIDE, CA. 92056-3512 (760)724-5300

STRUT ASSY

WIR CAGE CODE DWG NO. 647.7700
 B 07M26
 SCALE NONE

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1/4 - 28 THREAD

ORIGINAL DATE 11/03/00		APICAL INDUSTRIES	
DRAWN BY J. JACKSON		2608 TEMPLE HEIGHTS DR.	
DRAWING APPROVAL P. BRAVO		OCEANSIDE, CA. 92056-3512 (760)724-5300	
CONTRACT NO.		STRUT ASSY	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ± .01 3 PLACE DECIMALS ± .005 ANGLES ± .5°	SHEET B	CAGE CODE 07M26	DWG. NO. 647.7700
SCALE: NONE		SHEET 2 OF 2	

